

MU 0081660



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G26631-3G
Job Sheet 190180



Part No: RBW6305G26631-3G		Job Qty: 1 pcs
Part Name: Main Gear Box Alignment Pins		
Part Weight: 0 lbs	Status: New	Priority: Medium
Job Created: 2/5/19	Job Tracking No: SIOP	
Due Date: 3/15/19	Created By: Dara Macdonald	
Type: Stock	Description:	
Note: DWG RBW6305G26631-3G Rev. 2 IPP Rev. A 18.05.18 new issue DP Verify DD		
Ship Via:		

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	3/15/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 4	1 pcs	3/15/19		0.00	0.00	QC 4 - 26		
							QC 4 - 28		
							QC 4 - 38		
							QC 4 - 42		
							QC 4 - 58		
							QC 4 - 6		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		

5
JH
EXTERNAL LOAD - 2

Michael - AD 2017-02-27 Done

JH

DAS
2
9-89



Container No: S154283



Part: RBW6305G26631-3G

Job No: 190180

Serial No/Batch: S154283

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/15/19

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	3-36
140 QC 21 - FG	1 pcs	3/15/19	0.00 0.00		

MAR 05 2019

Part Op 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1400-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G26631-3G-5 to RBW6305G26631-3G-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - (QC4- 100% Inspect kits for completeness)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 1	5145 165
APP-1400-E	Case	1 Ea (1 ea)	110-Small Fab - 1	5082816
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	5010 7676
RBW6305G26631-3G-1	Pin	4 pcs (4 ea)	110-Small Fab - 1	5137918
RBW6305G26631-3G-3	Handle	4 pcs (4 ea)	110-Small Fab - 1	5139013
RBW6305G26631-3G-5	Placard	1 pcs (1 ea)	110-Small Fab - 1	5138 298
RBW6305G26631-3G-7	Bottom Foam use in case APP-1400-E	1 Ea (1 ea)	110-Small Fab - 1	5082817
RBW6305G26631-3G-9	Top Foam use in case APP-1400-E	1 Ea (1 ea)	110-Small Fab - 1	5082818

Job Allocations

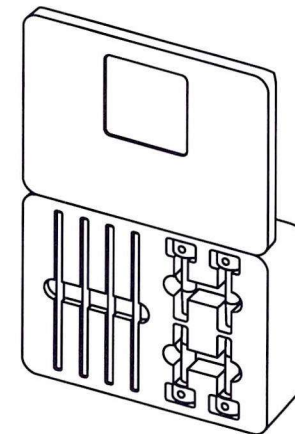
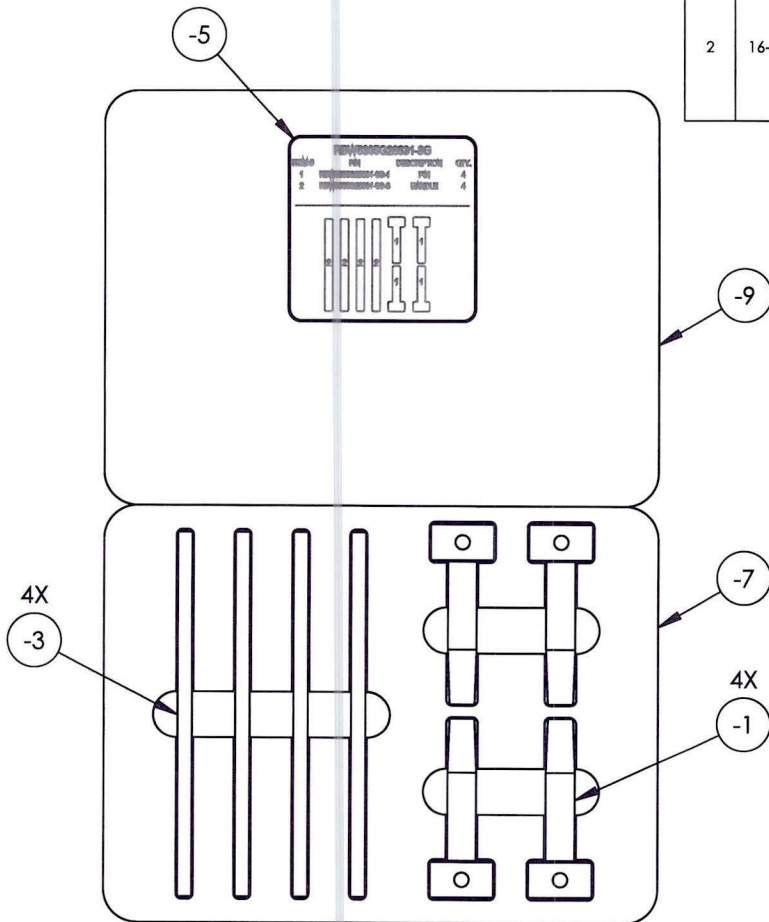
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	4	514	0
	APP-1400-E	1	9	0
	RB41011	1	419	0
	RBW6305G26631-3G-1 - Rev. PG	4	0	0
	RBW6305G26631-3G-3 - Rev. PG	4	1	0
	RBW6305G26631-3G-5	1	1	0
	RBW6305G26631-3G-7	1	3	0
	RBW6305G26631-3G-9	1	3	0

Part Specifications

Specifications could not be found.

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A	14-0156	CH'D TITLEBLOCK WAS RED BARN IS DART. -5 CH'D PART #'S ON CARD WAS RBW6305G26631-3 IS RBW6305G2661-3G-1, WAS RBW6305G26631-3 IS RBW6305G26631-3G-3.	9/19/2014	DJN	RJC
2	16-0132	-1 CH'D DIM WAS (Ø1.375) IS Ø1.38, WAS 3.935 IS 3.94, WAS (.83) IS .83, WAS Ø.313 S.F. -3 THRU ALL IS Ø.3168/.3150 THRU ALL (S.F. -3), ADDED DIM 2X .03 X 45°. -3 CH'D DIM WAS (Ø.313) IS .31 (S.F. -1), CH'D FINISH WAS BLACK ANODIZE, IS BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D. CH'D MATERIAL WAS 1018 IS 1018/1020 CR. -5, -7, -9 CH'D DWG. TO SHEET METAL TOLERANCES. -5 DELETED TEXT HT. NOTES, CH'D DIM WAS (.06) IS .06 ADDED NOTE USE PDF. -7, -9 CH'D MATERIAL & VENDOR WAS Y20 BLACK, I.R. SPECIALTIES IS ETHAFOAM 220 BLACK, (CASE SOLUTIONS). -7 DELETED DIM'S 4X .37, 4X 1.44, 4X 3.15, 4X .68, 4X .85, 4X R.72, ADDED DIM'S 6X R.50, 4X .75, 4X 45°, CH'D DIM WAS 3.95 IS 3.92, WAS Ψ.37 IS Ψ.34. -9 DELETED DIM 4X R.45, ADDED DIM'S 4X .45, 4X 45°, 1.00, CH'D DIM'S WAS 4.03 IS 4.06, WAS 1.20 IS 1.17.	11/10/2016	RJC	JAG



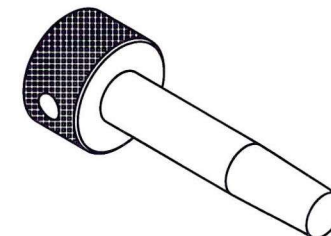
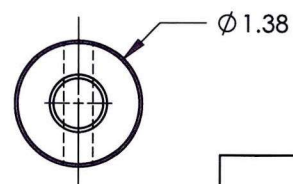
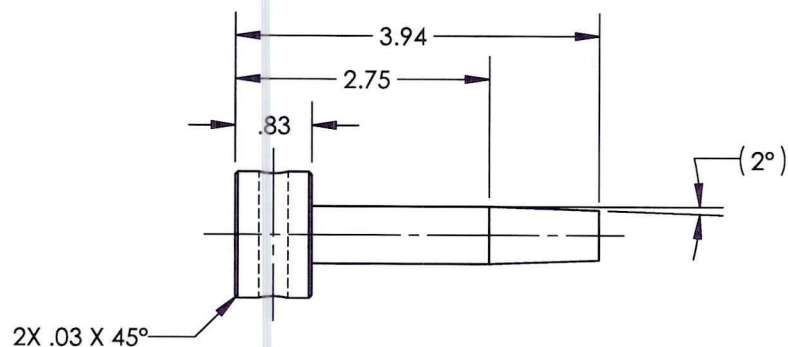
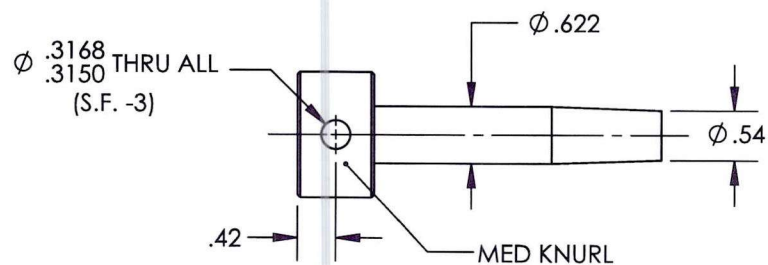
NOTE:
REF. AGUSTA T/N: 3G6305G26631.

			
TITLE			
MGB ALIGNMENT PINS			
DWG NO.			REV
RBW6305G26631-3G			2
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 ✓	
HEAT TREAT FINISH			
SPEC			
DRAWN BY: MARPET			
CHECKED: MACKOVJAK		USED ON MODEL AW139	
OPPS APPR: ANDERSON			
QA APPR: LINDSAY			
APPROVED: GILBERT			
SCALE	1:4	DATE	5/30/2013
		SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	4	PIN	BRASS		2
			-3	4	HANDLE	1018/1020 CR	(MCMaster-CARR #8920K265) MODIFIED	3
			-5	1	PLACARD	PLASTIC		4
		B/O	-7	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	3.92 X 9.08 X 11.98 (CASE SOLUTIONS)	5
		B/O	-9	1	TOP FOAM	ETHAFOAM 220, BLACK	1.17 X 9.08 X 11.98 (CASE SOLUTIONS)	6
		B/O	-11	1	CASE	PLASTIC, BLACK	PELICAN #APP-1400-E	N/S
		B/O		1	PLACARD	ALUMINUM	RB41011	N/S

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	16-0132	-1 CH'D DIM WAS (Ø1.375) IS Ø1.38, WAS 3.935 IS 3.94, WAS (.83) IS .83, WAS Ø.313 S.F. -3 THRU ALL IS Ø.3168/.3150 THRU ALL (S.F. -3), ADDED DIM 2X .03 X 45°.			11/10/2016	RJC	JAG



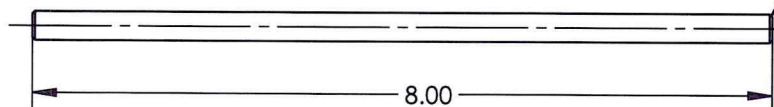
(-1)
PIN

DART AEROSPACE	
TITLE MGB ALIGNMENT PINS	
DWG NO. RBW6305G26631-3G-1	REV 2
MAT'L BRASS	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: MARPET	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:2	DATE 1/23/2013 SHEET 2 OF 6

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0132	-3 CH'D DIM WAS (Ø.313) IS .31 (S.F. -1). CH'D FINISH WAS BLACK ANODIZE, IS BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D, CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	11/10/2016	RJC	JAG

Ø.31
(S.F. -1)



2X .03 X 45°

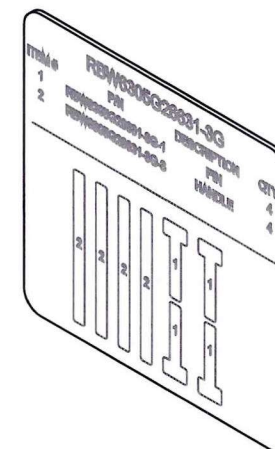
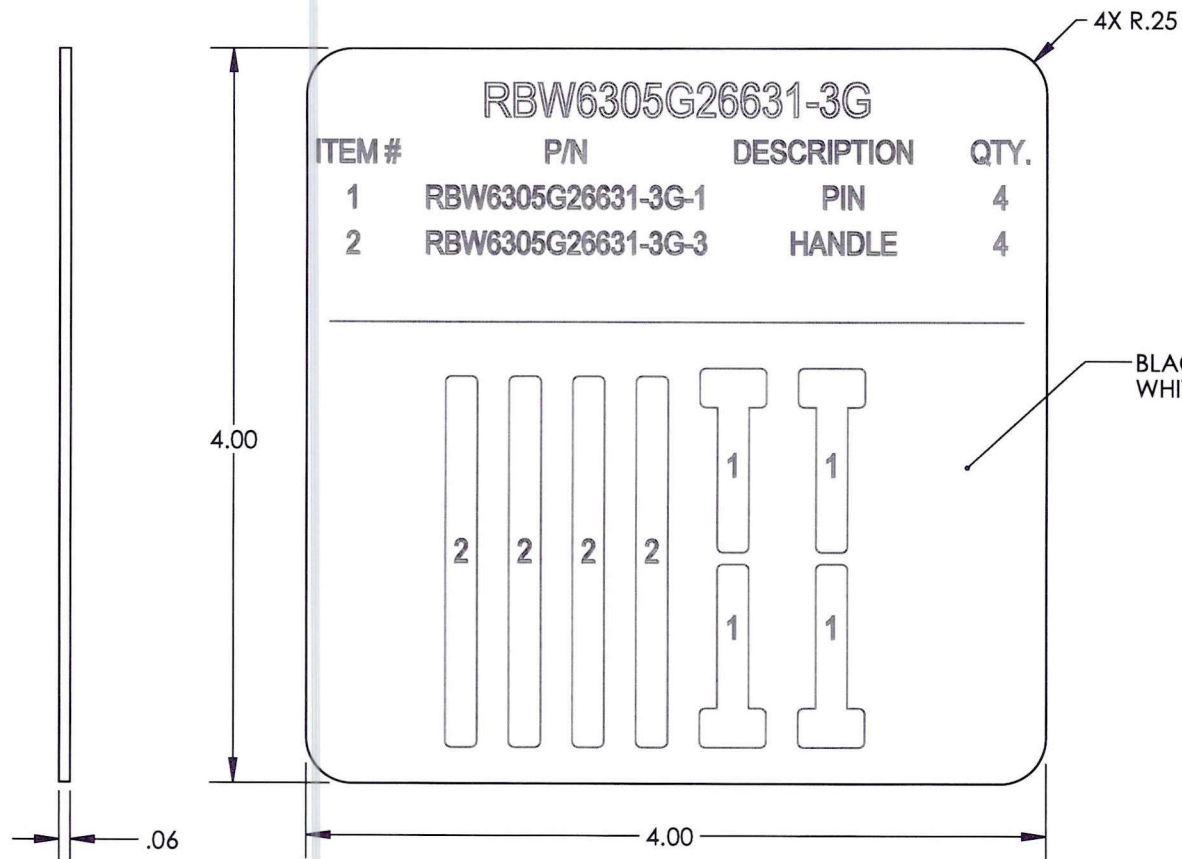
(-3)

HANDLE

DART AEROSPACE	
TITLE MGB ALIGNMENT PINS	
DWG NO. RBW6305G26631-3G-3	REV 2
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: MARPET	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:2	DATE 1/23/2013
SHEET 3 OF 6	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D PART #'S ON CARD WAS RBW6305G26631-3 IS RBW6305G2661-3G-1, WAS RBW6305G26631-3 IS RBW6305G26631-3G-3.	11/9/2016		
2	16-0132	-5 DELETED TEXT HT, NOTES, CH'D DIM WAS (.06) IS .06 ADDED NOTE USE PDF, CH'D DWG TO SHEET METAL TOLERANCES.	11/10/2016	RJC	JAG



BLACK BACKGROUND W/
WHITE LINES AND LETTERS

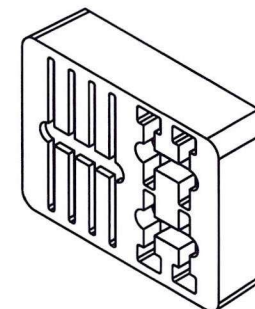
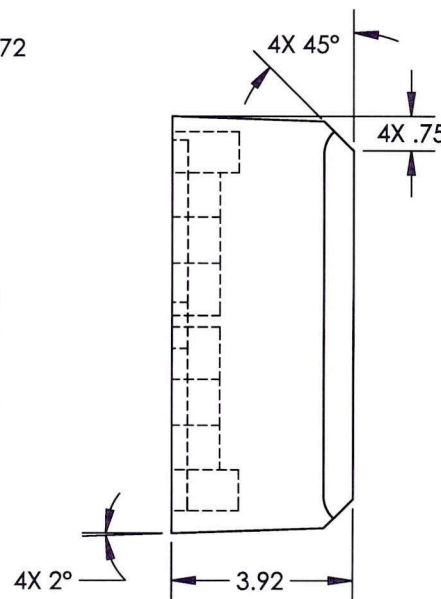
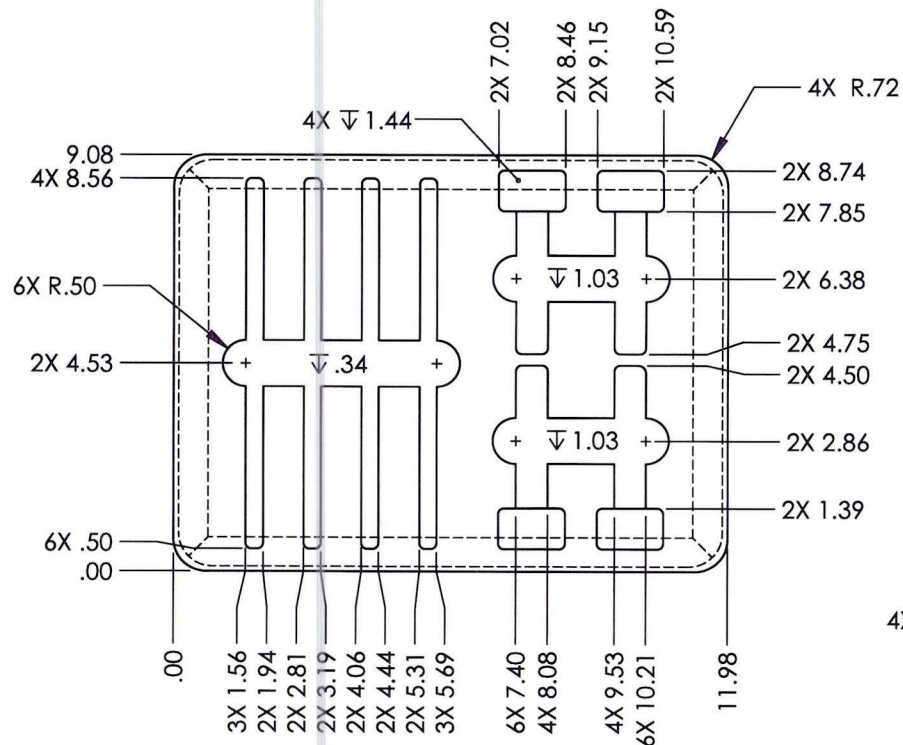
NOTE:
USE PDF.

(-5)
PLACARD

DART AEROSPACE	
TITLE MGB ALIGNMENT PINS	
DWG NO. RBW6305G26631-3G-5	REV 2
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ±1°
FINISH	.X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MARPET	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	AW139
APPROVED: GILBERT	
SCALE 1:1	DATE 5/30/2013 SHEET 4 OF 6

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0132	-7 DELETED DIM'S 4X .37, 4X 1.44, 4X 3.15, 4X .68, 4X .85, 4X R.72, ADDED DIM'S 6X R.50, 4X .75, 4X 45°, CH'D DIM WAS 3.95 IS 3.92, WAS ∇ .37 IS ∇ .34, CH'D MATERIAL & VENDOR WAS Y20 BLACK, I.R. SPECIALTIES IS ETHAFOAM 220 BLACK, (CASE SOLUTIONS), CH'D DWG. TO SHEET METAL TOLERANCES.	11/10/2016	RJC	JAG



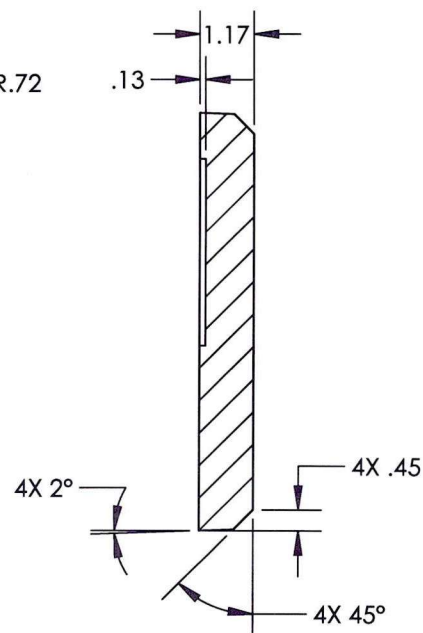
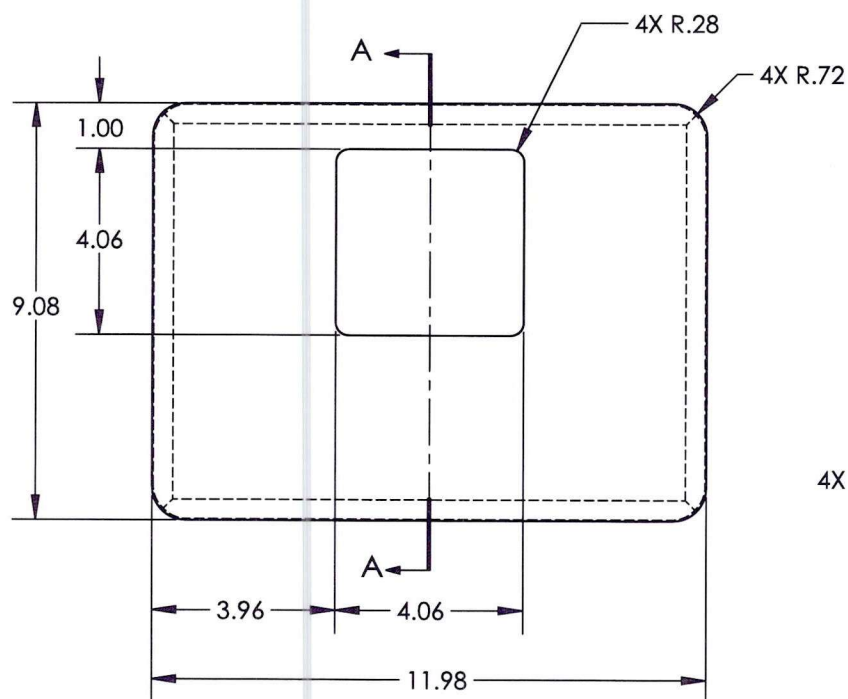
(-7)

BOTTOM FOAM

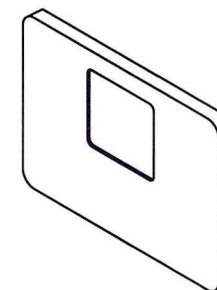
DART AEROSPACE	
TITLE MGB ALIGNMENT PINS	
DWG NO. RBW6305G26631-3G-7	REV 2
MAT'L ETHAFOAM 220, BLACK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH FINISH	.XX ± .03 ANGLES ± 1°
SPEC SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: MARPET	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:4	DATE 5/30/2013
SHEET 5 OF 6	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0132	-9 DELETED DIM 4X R.45, ADDED DIM'S 4X .45, 4X 45°, 1.00, CH'D DIM'S WAS 4.03 IS 4.06, WAS 1.20 IS 1.17, CH'D MATERIAL & VENDOR WAS Y20 BLACK, I.R. SPECIALTIES IS ETHAFOAM 220 BLACK, (CASE SOLUTIONS), CH'D DWG. TO SHEET METAL TOLERANCES.	11/10/2016	RJC	JAG



SECTION A-A



(-9)
TOP FOAM

DART AEROSPACE	
TITLE MGB ALIGNMENT PINS	
DWG NO. RBW6305G26631-3G-9	REV 2
MAT'L ETHAFOAM 220, BLACK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MARPET	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:4	DATE 5/30/2013 SHEET 6 OF 6

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					